

REVISONS				
REV/ECN NO	DESCRIPTION		BY	DATE
1 35580	RELEASE FOR QUOTE		DES	1/30/14
2 35738	RELEASE FOR TOOLING		DES	4/10/14
3 35763	FIX UNINTENDED UNDERCUT NEAR BATTERY HOLDER, 3-D MODEL CHANGE ONLY.		DES	4/15/14
4 35794	ADD INSERT AREA FOR FUTURE MARKINGS		DES	4/30/14
5 35877	ADD AGENCY MARKINGS TO INSERTED AREA		DES	6/12/14

D

C

B

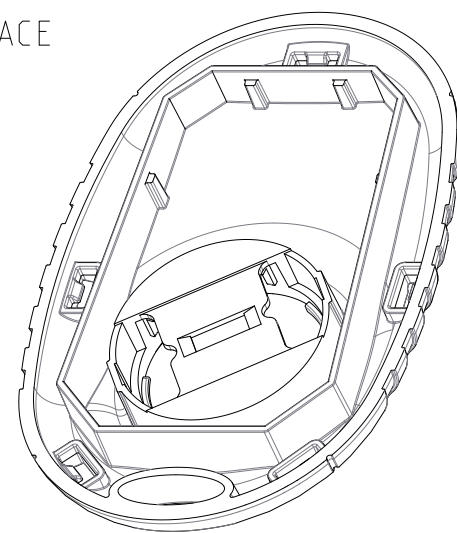
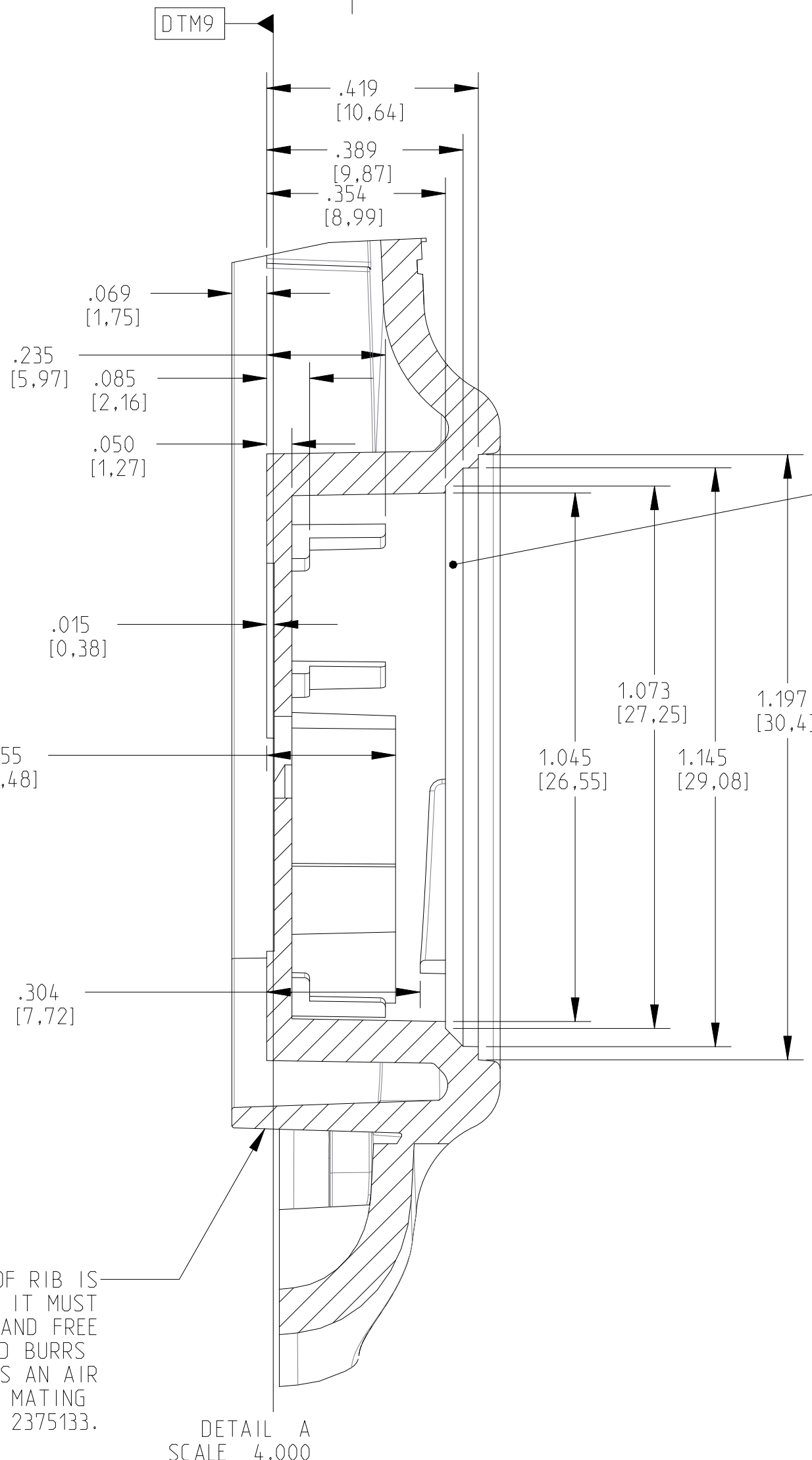
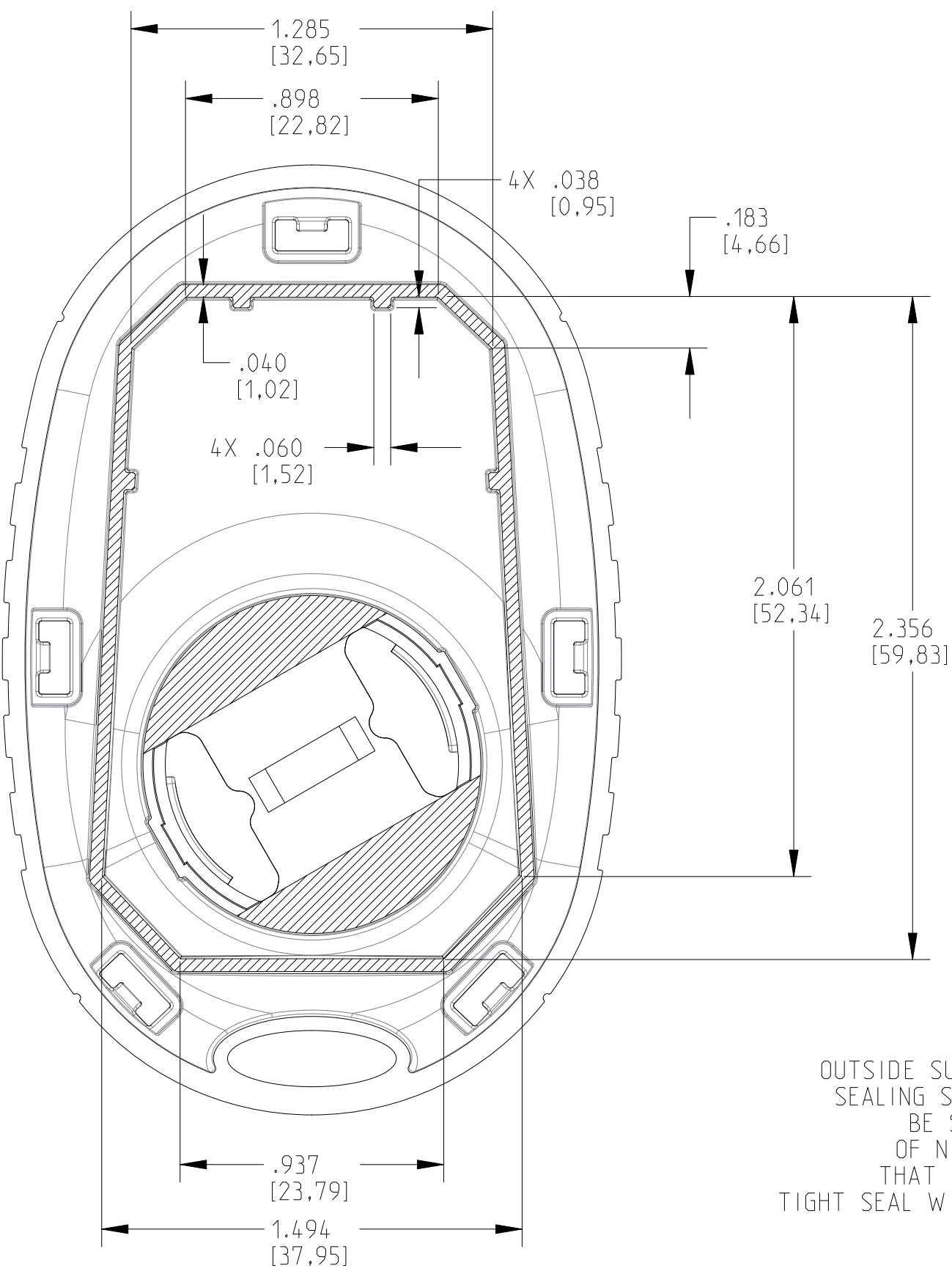
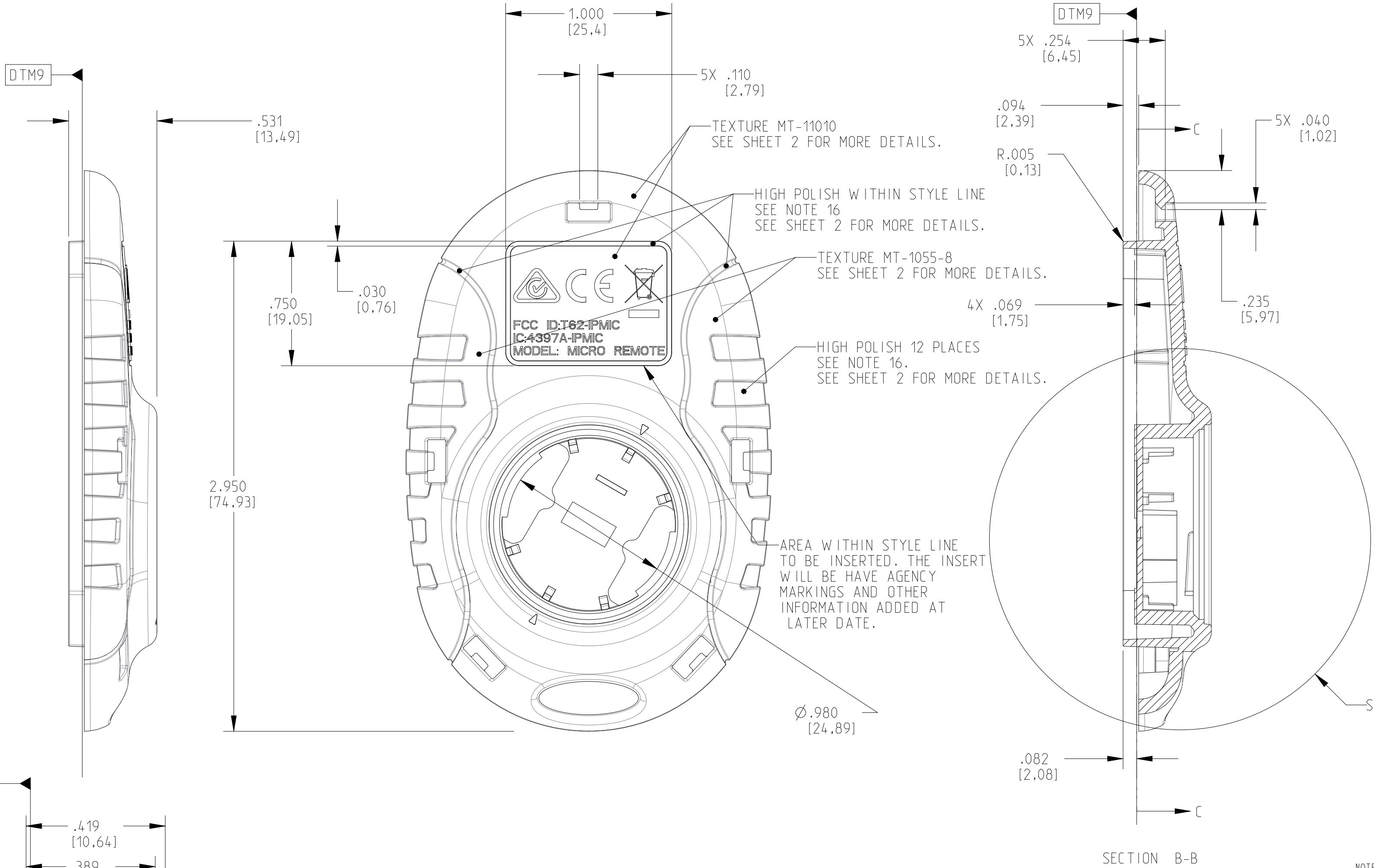
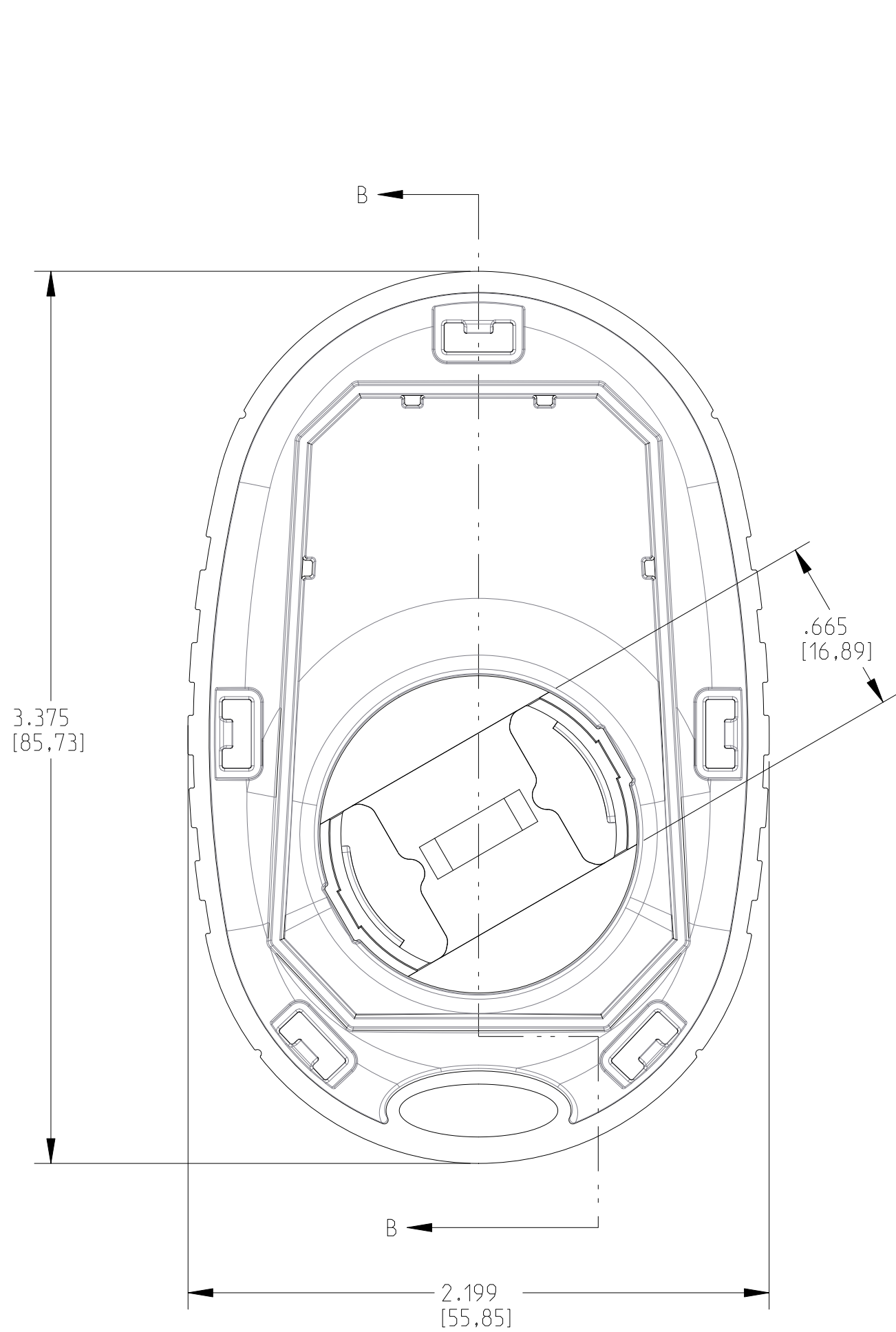
A

D

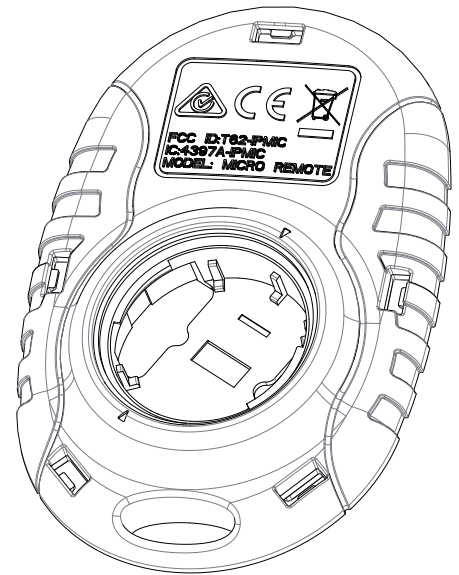
C

B

A



SCALE 1.000



SCALE 1.000

OUTSIDE SURFACE OF RIB IS SEALING SURFACE. IT MUST BE SMOOTH AND FREE OF NICKS AND BURRS THAT PREVENTS AN AIR TIGHT SEAL WITH THE MATING PART 2375133.

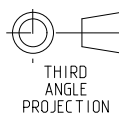
DETAIL A
SCALE 4.000

NOTES:

- MATERIAL:
SABIC LEXAN 143R-701, COLOR: BLACK
MATERIAL REGRIND: NOT ALLOWED
VOLUME: 0.7049 IN³
- COSMETIC SURFACE QUALITY:
UNLESS OTHERWISE SPECIFIED ALL EXTERIOR SURFACES TO BE PER SPI "COSMETIC SPECIFICATION OF INJECTION MOLDED PARTS" GRADE 1, SURFACE A
- MATERIAL PROCESSING:
ALL MATERIALS MUST BE PROCESSED WITHIN THE MATERIAL MANUFACTURER'S SPECIFIED PROCESSING PROPERTIES UNLESS OTHERWISE AUTHORIZED BY JOI ENGINEERING.
- TEXTURING:
ALL EXTERIOR SURFACES TO BE TEXTURED AS NOTED
ALL INTERIOR OR CORE FEATURES TO BE FINISHED FOR SMOOTH AND REPEATABLE PART EJECTION FROM TOOL
ALL TEXTURING TO BE APPLIED AFTER SAMPLES HAVE BEEN SUBMITTED TO JOI AND UPON JOI APPROVAL OF ALL DIMENSIONS
- FILLETS AND RADII: PER 3-D DATABASE, R.005 MINIMUM UNLESS OTHERWISE SPECIFIED.
- FLASH AND BURRS TO BE .005 MAXIMUM UNLESS OTHERWISE SPECIFIED.
- GATES, PARTING LINES, WELD LINES AND EJECTOR PIN LOCATIONS TO BE APPROVED BY JOI ENGINEERING PRIOR TO TOOL CREATION. EJECTOR PIN MARKS TO BE FLUSH WITH PART SURFACE +.005/- .010.
- PART TO BE TOOLED PER 3-D DATABASE PROVIDED BY JOI ENGINEERING. DIMENSIONS SHOWN ON DRAWING MUST BE MEASURED ON THE FIRST ARTICLE INSPECTION REPORT. FOR ALL OTHER NON-DIMENSIONED FEATURES USE 3-D DATABASE.
- DRAFT ANGLES AND DIRECTION DETERMINED BY 3-D DATABASE. DURING MOLD DESIGN BY TOOLMAKER/SUPPLIER DRAFT & PART GEOMETRY MUST BE REVIEWED. IF DRAFT IS REQUIRED, PREFERRED, OR IN NEED OF MODIFICATION IT IS THE RESPONSIBILITY OF THE TOOLMAKER/SUPPLIER TO NOTIFY JOI ENGINEERING FOR REVIEW AND POSSIBLE UPDATE OF PART GEOMETRY.
- FOR DIMENSIONS SHOWN TO CORNERS WITH RADII ASSUME DIMENSION APPLIES TO THEORETICAL SHARP CORNER (INCLUDING DRAFT IF APPLICABLE) UNLESS OTHERWISE SPECIFIED.
- JOI ENGINEERING MUST REVIEW AND APPROVE ALL PRINTS AND DATABASES ASSOCIATED PRIOR TO TOOLING, RELOCATING, OR RETOOLING OF THIS PART.
- CAVITY # REQUIRED FOR MULTIPLE CAVITIES. NOMENCLATURE TO BE RAISED OR RECESSED .015 MAX ABOVE OR BELOW SURFACE. CHARACTER HEIGHT TO BE .05 MINIMUM/.100 MAXIMUM.
- STEEL SAFE DIMENSIONS ON PART FEATURES ARE TO BE MADE OUT OF TOLERANCE BY X.XX" ON INITIAL PART SAMPLING. THESE FEATURES WILL THEN BE READJUSTED TO WITHIN NOMINAL PRINT. DIMENSIONS AFTER INITIAL SAMPLES ARE INSPECTED.
- PART TO BE FREE OF OILS, LUBRICANTS, MOLD RELEASE, AND ANY FOREIGN DEBRIS AND PACKAGED TO PREVENT DAMAGE DURING SHIPMENT.
- PART MUST MATE AND FIT WITH PART NUMBER 2372570.
- HIGH POLISH SURFACE TO MEET SPI "COSMETIC SPECIFICATION OF INJECTION MOLDED PARTS" GRADE 1, SURFACE A.

TOLERANCES: UNLESS OTHERWISE SPECIFIED
XXXX ±.0010 2X ±.015
XXX ±.005 FRACTIONAL ±.004
XX ±.010 ANGULAR ±0°30'

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QUALITY REQUIREMENTS: Limited dimensions are critical. Dimensions marked * require Proof of Quality with each shipment.

REHS2 AND REACH COMPLIANCE: Supplier certifies that this part complies with 2011/65/EU REHS2 and EC No 1907/2006 EU REACH. Upon request, supplier will furnish verification of compliance via JOI form, supplier declaration or analytical testing referencing JOI part number.

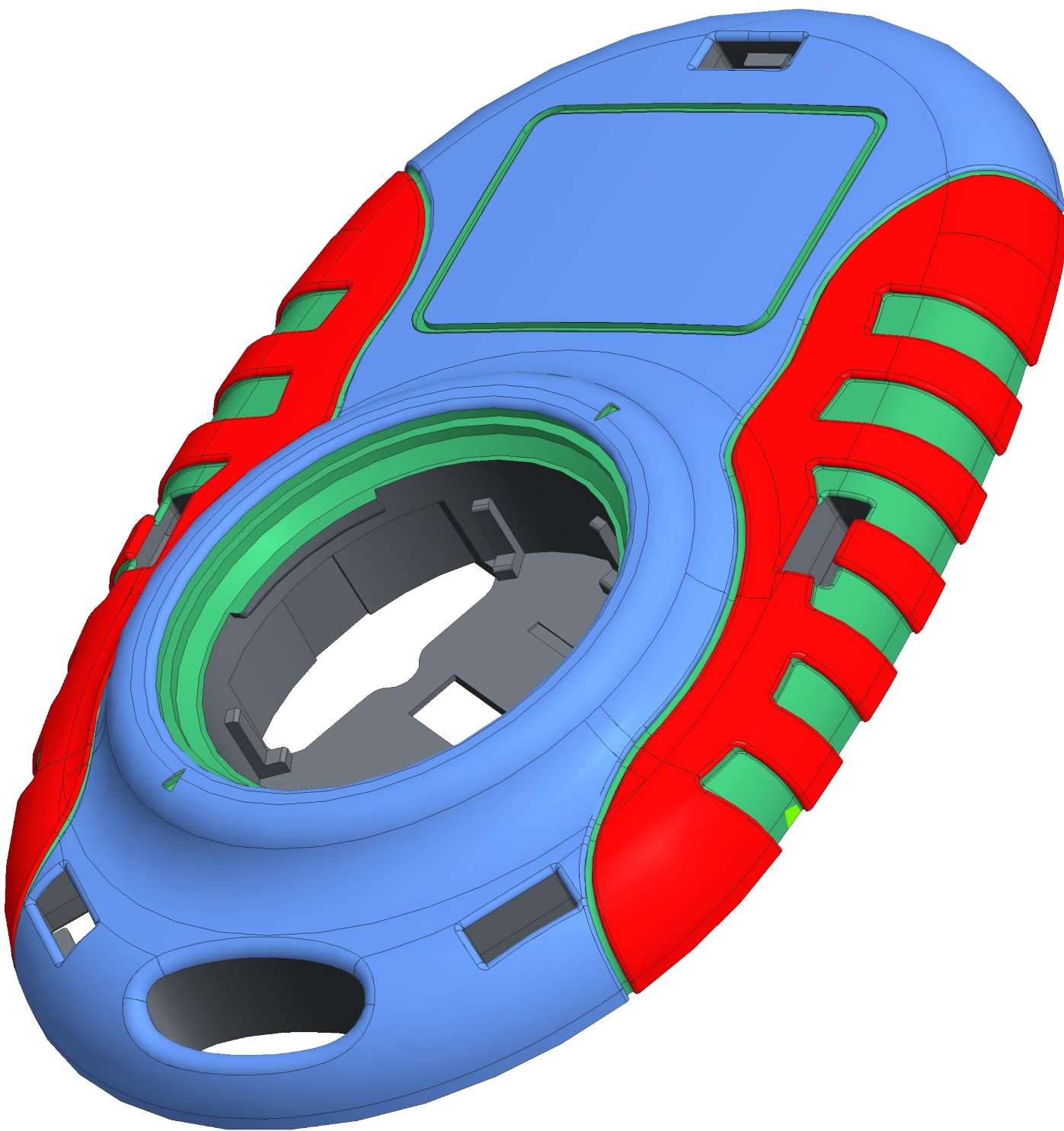
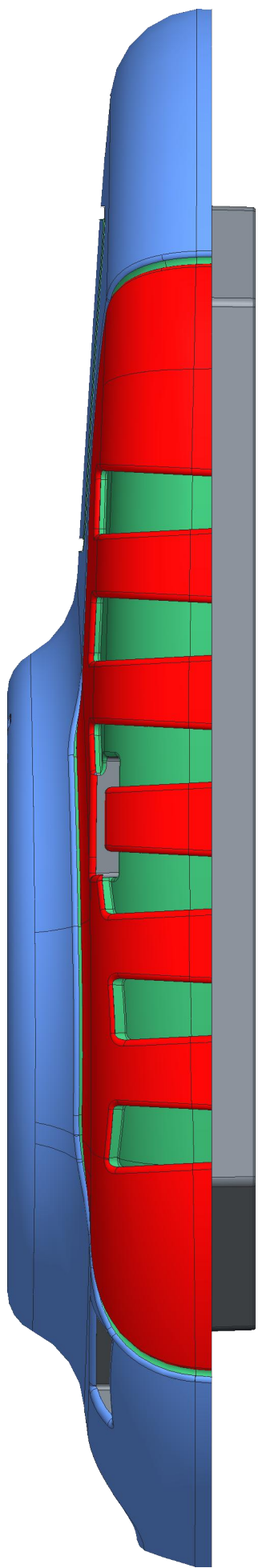
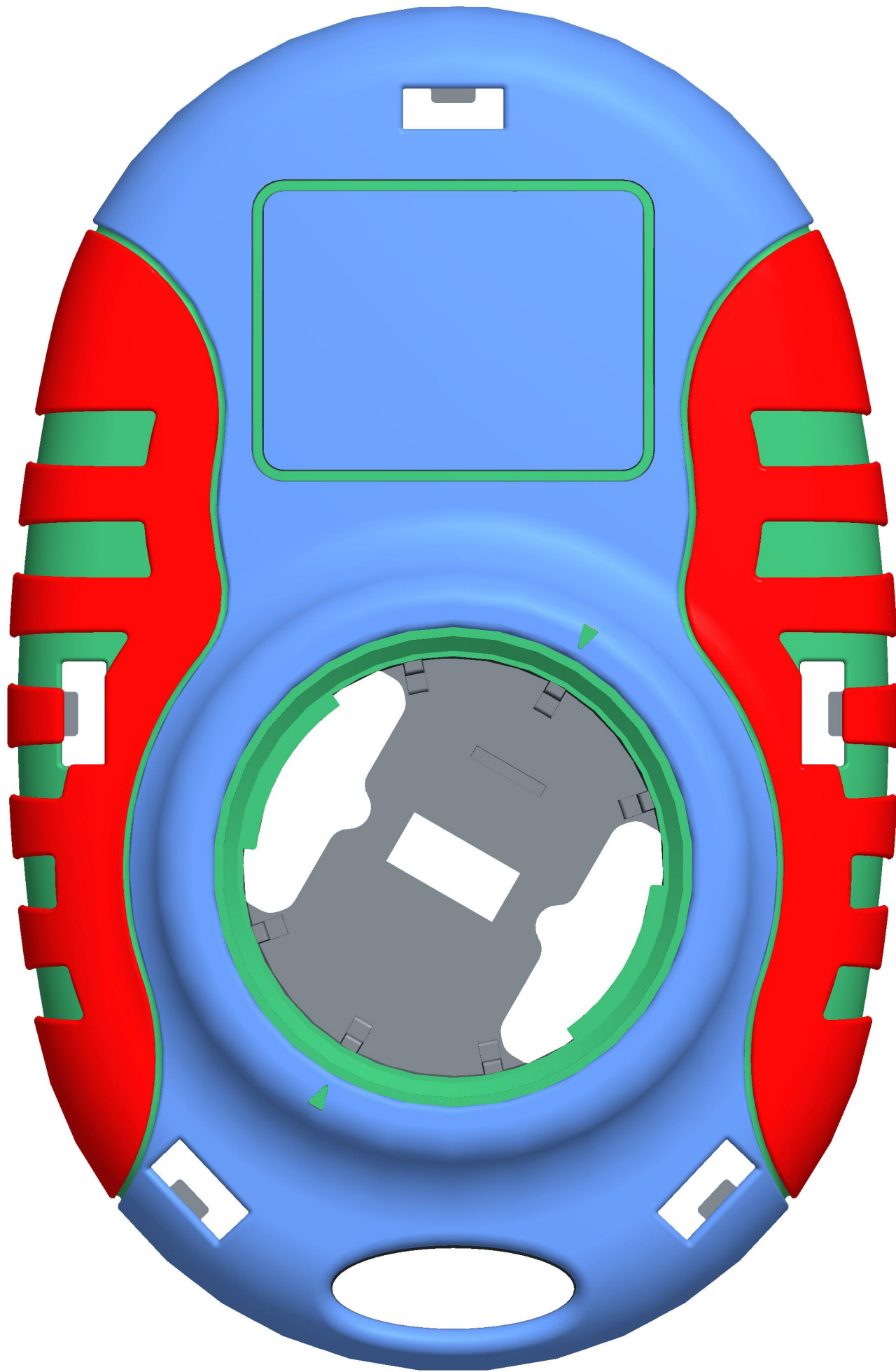
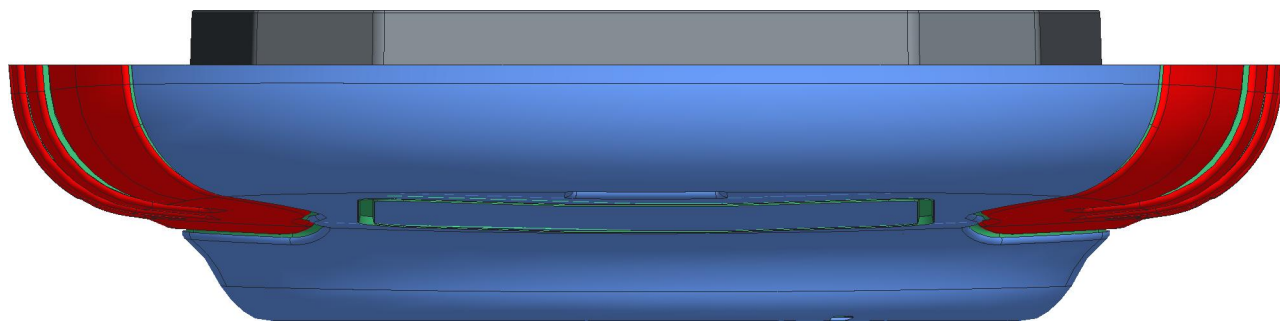
JOHNSON OUTDOORS
MARINE ELECTRONICS, INC.
PART NAME HOUSING BACK

PART NO. 2372575

U/M: IN. SHEET 1 OF 2 REV: 5

DRAWN BY: DES DATE: 1/30/14
SCALE: 2.0:1
LIFECYCLE STATUS: Concept

REVISIONS				
REV/ECH	NO	DESCRIPTION	BY	DATE
		SEE SHEET 1 FOR DETAILS		



TEXTURE DETAILS:

1. RED COLORED AREAS TO BE TEXTURED TO MT-1055-8
2. GREEN COLORED AREAS TO BE HIGH POLISH SURFACE TO MEET SPI "COSMETIC SPECIFICATION OF INJECTION MOLDED PARTS" GRADE 1, SURFACE A.
3. BLUE COLORED AREAS TO BE TEXTURED TO MT-11010

TOLERANCES: UNLESS OTHERWISE SPECIFIED

.XXXX ±.0010	XX	±.015
.XXX ±.005	FRACTIONAL	±1/64
.XX ±.010	ANGULAR	±0°30'

RoHS2 AND REACH COMPLIANCE:
Supplier certifies that this part complies with 2011/65/EU (EU RoHS2) and (EC) No 1907/2006 (EU REACH). Upon request, supplier will furnish verification of compliance via JDI form, supplier declaration or analytical testing referencing JDI part number.

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QUALITY REQUIREMENTS:
Limited dimensions are critical. Dimensions marked * require Proof of Quality with each shipment.

THIRD ANGLE PROJECTION

DRAWN BY: DES
DATE: 4/10/14
SCALE: 2.0:1

MATERIAL:
LIFECYCLE STATUS: Concept

U/M: IN.
SHEET 2 OF 2

REV: 5

JOHNSON OUTDOORS
MARINE ELECTRONICS, INC.
PART NAME: HOUSING BACK
PART NO.: 2372575